

T 5/45  
DART AEROSPACE LTD.

Work Order:

24433

Description: Saddle Fitting, Fwd (Outboard/Inboard)

Part Number:

D2571/D2572

Drawing: D2571 Rev. D/D2572 Rev. D

Qty:

8

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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	JS	05.10.12	8
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: B24293	SG	05/12/23	8
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: B21817-A	SG	05/12/23	8
4	MV	Fixturing W/O No. Fixturing Inspection last completed by		N/A	
5	MV	Program Batch No. 24433 Double check by: ES	JL	05.12.28	8
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	MS	06/01/03	8
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	MS	06/01/03	8
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	MS	06/01/03	8
9	MV	Machine keyway as per dwg D2571 & D2572	MS	06/01/09	8
10	MV	Deburr and remove all machining marks	MS	06/01/03	8
11	MV	Tumble for 20 minutes to remove sharp edges # 04.06.21 N/A	MS	06/01/09	8
12	QC1	Inspect all dimensions to dimension sheets	MS	06/01/09	8
13	QC7	Second inspection	MS	06/01/09	2
14	FP	Acid etch and alodine as per QSI 005 4.1	MS	06 01 09	2
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	MS	06 01 10	2
16	QC3	Inspect Powder Coat	MS	06/01/10	2
17	ST	Identify and Stock.	MS	06/01/10	2
18	AC	Cost / Part	MS	06 01 11	2
19	DC	Close W/O Inspection Level 21	MS	06/01/11	2

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	

RELEASED  
02/10/15 RF

